

# Work Order ID 75577

**\*75577\***

Page 1

October-25-11 3:11:45 PM

Item ID: D3325-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: **\*NS2\***  
 Item Name: Basket Lid Assembly  
 Start Date: 25/10/2011 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 08/11/2011 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: M.C.J Date: 11/10/25 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3325	Rev B								

100  
**\*100\***  
 Large Fab  
 Large Fab  
 Large Fab

Large Fab

0.00

0.00

Memo

1-Cut tubes as per Dwg D3325

QtyPart Number Description Batch  
 2D3325-1EndTube M109127  
 3D3325-3Interior Tube M109127  
 2D3325-5Full Lengh Tube M119441

Identify parts appropriately

2-Remove all markings from material

3-Drill and Weld as per Dwg D3325 & QSI 004  
 A/R4130Steel Rod M113875

4-Deburr as required

11.11.03

14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**Work Order ID 75577****\*75577\***

Page 2

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 <b>*110*</b> QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds  Memo	0.00  0.00				1	0	3E11/11/04	
120 <b>*120*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				W/	11	11	04 ①
121 <b>*121*</b> HandFinish Hand Finishing	Pressure Wash per QSI005 4.3  Memo	0.00  0.00				IXØM	11	11	04

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<div style="display: flex; justify-content: space-between;"> <div style="width: 45%;"> <p><b>Memo</b></p> <p>1ST COAT: <u>1:10</u></p> <p>START TIME: <u>4:00</u></p> <p>OVEN TEMPERATURE: <u>400°F</u></p> <p>FINISH TIME: <u>1:40</u></p> <p>***** 2nd coat if necessary*****</p> <p>2ND COAT: <u>2:10</u></p> <p>START TIME: <u>4:00</u></p> <p>OVEN TEMPERATURE: <u>400°F</u></p> <p>FINISH TIME: <u>2:50</u></p> </div> <div style="width: 50%; text-align: right;"> <p><i>Handwritten signature and date: 11/11/11</i></p> </div> </div>									
140 <b>*140*</b> QC	QC3- Inspect Part Finish	0.00							
<div style="display: flex; justify-content: space-between;"> <div style="width: 45%;"> <p><b>Memo</b></p> </div> <div style="width: 50%; text-align: right;"> <p><i>Handwritten signature and date: 11/11/11</i></p> </div> </div>									

*M118439*

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

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 Reference:

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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>CA</u>	0.00							
<b>*150*</b>									
Packaging	Memo <u>w/o</u>	0.00							
Packaging	<u>75571</u>								
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

*[Handwritten signature]* 11/11/07

*[Handwritten signature]* 11/11/07

*[Handwritten signature]* 11/11/07

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries



# Picklist Print

October-25-11 3:11:50 PM

Page 1

Work Order ID: 75577

\*75577\*

Parent Item: D3325-041

\*D3325-041\*

Parent Item Name: Basket Lid Assembly

Start Date: 25/10/2011

Required Date: 08/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A05.02.09New issueKJ/JLM  
IPP Rev:B 08-12-16 attach DEO DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3328-1 / *D3328-1* Basket Hinge		Manufactured	No			100	Each	23.0000	2	2	**	11/10/26	
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>						
			WA005		23								
			33871		23				(2x)				
D3349-1 / *D3349-1* Spacer Bushing		Manufactured	No			100	Each	28.0000	2	2	**	11/10/26	
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>						
			WA005		28								
			44401		28				(2x)				
D3352-1 / *D3352-1* Label Plate		Manufactured	No			100	Each	14.0000	1	1	**	11/10/26	
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>						
			WA005		14								
			41925		14				(1x)				
D3367-1 ✓ *D3367-1* Mounting Bracket		Manufactured	No			100	Each	20.0000	2	2	**	11/10/26	
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>						
			WA005		20								
			43228		20				(2x)				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

October-25-11 3:11:50 PM

Page 2

Work Order ID: 75577

**\*75577\***

Parent Item: D3325-041

**\*D3325-041\***

Parent Item Name: Basket Lid Assembly

Start Date: 25/10/2011

Required Date: 08/11/2011

Start Qty: 1.00

Required Qty: 1.00

M4130NTS0.500W.035

Purchased

No

100

f

270.9988

20.5416

21.62274

**\*M4130NTS0 500W 035\***

4130 Square tube .500 x .500 x .035w

\*\*

3119441

14.41

11/10/26

Location

Loc Qty

Loc Code

MAT034

270.9988

109127

216

109385

15.75

112786

39.2488

7.21

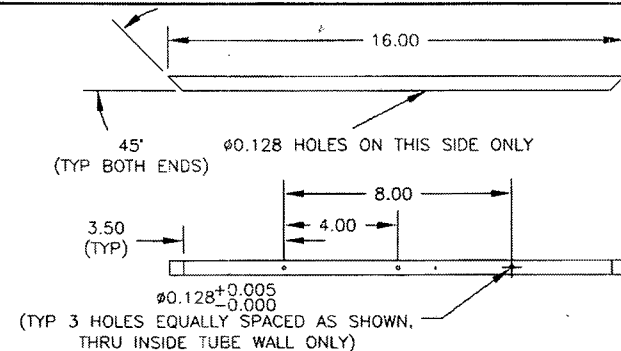
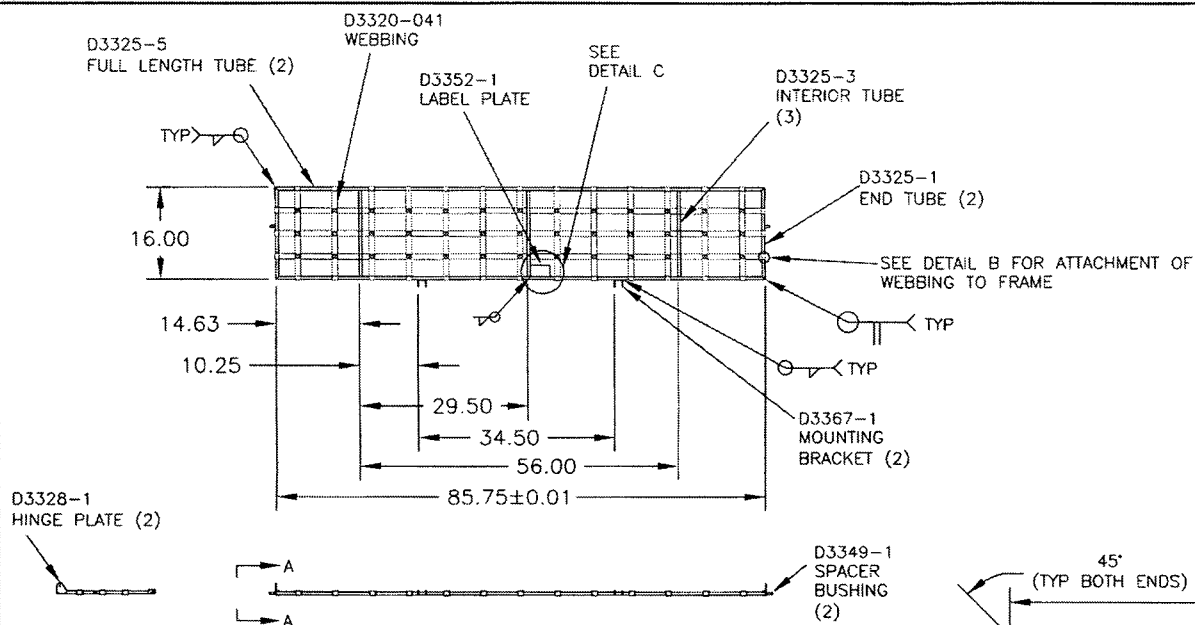
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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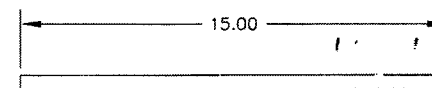
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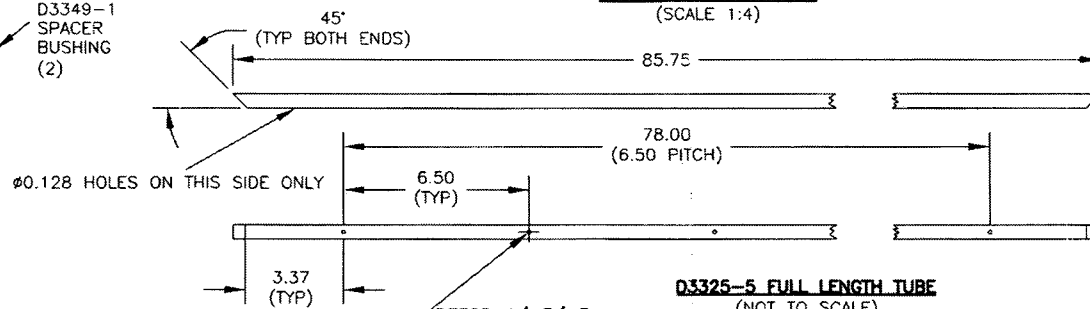
**NOTE:** Date & initial all entries



**D3325-1 END TUBE**  
(SCALE 1:4)



**D3325-3 INTERIOR TUBE**  
(SCALE 1:4)



**D3325-5 FULL LENGTH TUBE**  
(NOT TO SCALE)

**D3325-041 BASKET LID ASSEMBLY**

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3 (PRIOR TO INSTALLATION OF D3320-041)
- 2) WELD PER DART QSI 004
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**PARTS LIST FOR D3325-041 BASKET LID ASSEMBLY**

Part No.	Quantity	Description
D2729-1	1	PRODUCT ID LABEL
D3320-041	1	WEBBING
D3325-1	2	END TUBE
D3325-3	3	INTERIOR TUBE
D3325-5	2	FULL LENGTH TUBE
D3328-1	2	HINGE PLATE
D3349-1	2	SPACER BUSHING
D3351-1	1	PLACARD
D3352-1	1	LABEL PLATE
D3367-1	2	MOUNTING BRACKET
MS20600AD4V3	32	RIVET
AN960JD9	32	WASHER

SHOP COPY (TYP 13 HOLES, EQUALLY SPACED, THRU INSIDE TUBE WALL ONLY)  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 75577 H.L.J  
11/10/25

**D3325-1/-3/-5**

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE, AMS-T-6736, 1/2" X 0.035 (REF. DART SPEC M4130N-TS0.500W.035)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

B	05.04.25	CHANGE RIVET AND HOLE DIAMETER
A	04.10.21	NEW ISSUE
DESIGN	DH	DRAWN BY
CHECKED	JH	APPROVED
DATE	05.04.25	TITLE
		BASKET LID ASSEMBLY
		SCALE
		1:20

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**DART** DART AEROSPACE LTD.  
WILKESBORO, ONTARIO, CANADA

DRAWING NO. D3325  
SHEET 1 OF 3  
REV. B

RELEASED  
05-04-25

DEO ATTACHED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

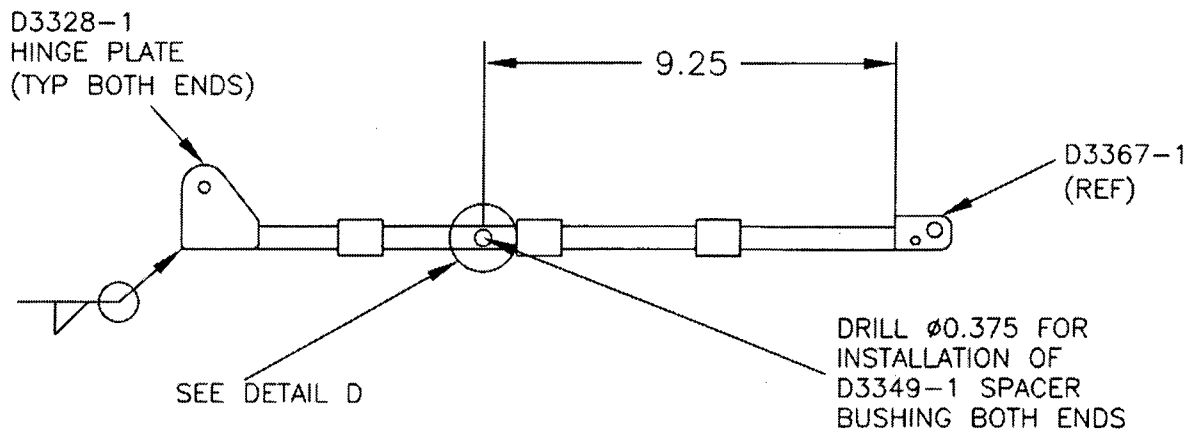
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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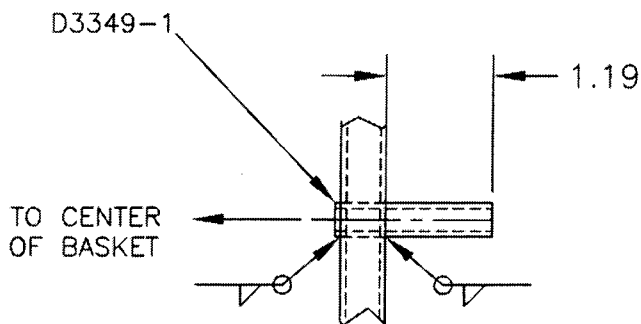
**NOTE:** Date & initial all entries



DESIGN AH	DRAWN BY AH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3325	REV. B SHEET 2 OF 3
DATE 05.04.25		TITLE BASKET LID ASSEMBLY	SCALE 1:4



VIEW A-A



DETAIL D  
(SCALE 1:2)

DEO ATTACHED  
RELEASED  
05.04.28 [Signature]

test

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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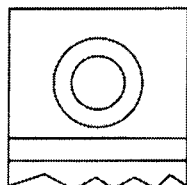
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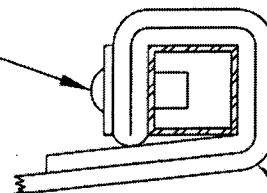


DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED PH	DRAWING NO. D3325	REV. B SHEET 3 OF 3
DATE 05.04.25		TITLE BASKET LID ASSEMBLY	SCALE 1:4

MS20600AD4W3 RIVET (1)  
AN960JD9 WASHER (1)



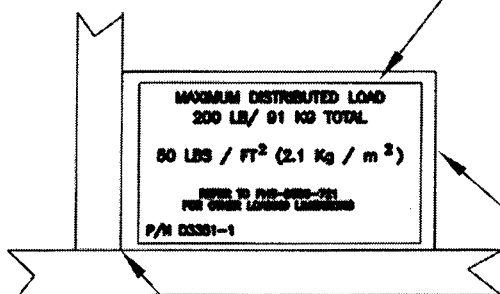
DETAIL B  
TYP. ATTACHMENT OF WEBBING TO LID  
FRAME  
(SCALE 1:1)



D3320-041 WEBBING

RELEASED  
05.04.28  
DEO ATTACHED

ATTACH D3351-1 PLACARD  
ON TOPSIDE OF D3352-1



D3352-1

OUTBOARD

IDENTIFY WITH DART P/N  
D350-721-041 USING  
D2729-1 PRODUCT ID LABEL  
INSTALLED ON UNDERSIDE OF  
D3352-1

DETAIL C  
LABEL PLATE ATTACHMENT  
(SCALE 1:2)

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75577

DRAWING NO. D3325	TITLE BASKET LID ASSEMBLY	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3325-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>			
DATE 08.11.28	DATE 08.11.28	DATE 08.12.01	DATE 08.12.01	DATE 08.12.01	DATE 08.12.01		

1) SHEET 1 MODIFY PARTS LIST AS SHOWN:

**PART LIST FOR D3325-041 BASKET LID ASSEMBLY**

Part No.	Quantity	Description

**IS:**

MS20600AD4W5	32	RIVET
--------------	----	-------

**WAS:**

MS20600AD4W3	32	RIVET
--------------	----	-------

2) UPDATE SHEET 3 DETAIL B ACCORDINGLY.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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